



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3121-143
Job Sheet 181849



Part No: D3121-143

Job Qty: 10 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/9/18

Job Tracking No:

Due Date: 8/17/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by:EC IPP
Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	8/17/18	8/17/18	0.00	0.00	Start Up Machining-1		MM
100	Bandsaw	10 pcs	8/17/18	8/17/18	0.00	3.68	Bandsaw1		MM
110	CNC Vertical Machining	10 pcs	8/17/18	8/17/18	0.41	21.28	HAAS1-3		MM
120	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC2 Machining-1		MM
130	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC8 Machining-1		MM
140	Small Fab	10 pcs	8/17/18	8/17/18	0.00	0.46	Small Fab-2		MM
150	QC	10 pcs	8/17/18	8/17/18	0.00	0.00	QC5		MM
160	Packaging	10 pcs	8/17/18	8/17/18	0.00	0.00	Packaging3-1		MM
170	QC21-SA	10 Ea	8/17/18	8/17/18	0.00	0.00	QC21		MM

Part Op 100 - Cut blanks: (1.250" x 2.000") 4.425" long
Descriptions: 110 - 1-Machine D3121-113 as per Folio FA330 and Dwg D3121
140 - Assemble D3121-143 as per Dwg D3121.

21 OCT 11 2018
9:39 OCT 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	3.6800 ft (.368 ea)	90-Start up Operation	
D3121-21	Bolt	20 Ea (2 ea)	140-Small Fab	5049417 9x 5097200 11x
D3121-241	Bearing Assembly	20 Ea (2 ea)	140-Small Fab	5116789

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.250X2.000	4	26	0
140-Small Fab	D3121-21	20	115	0
	D3121-241	20	10	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	181845
Description: Bracket		Part Number:	D3121-113
Inspection Dwg: D3121	Rev: E	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.081	✓		Vernier	
0.300	+/-0.010	.299	✓		Vernier	
R0.375	+/-0.010	R.375	✓		Gaborit	
1.54	+/-0.030	1.545	✓		Vernier	
0.350	+/-0.010	.350	✓		high gage	
R0.25	+/-0.030	R.250	✓		Gaborit	
Ø0.392	+0.002/-0.000	.393	✓		micronale / bearing	
Ø0.201	+/-0.010	.2018	✓		Pin gage	
2.540	+/-0.010	2.539	✓		Vernier	
1.590	+/-0.010	1.588	✓		Vernier	
0.160	+/-0.010	.161	✓		Vernier	
0.400	+/-0.010	.393	✓		Vernier	
1.220	+/-0.010	1.217	✓		Vernier	
1.600	+/-0.010	1.602	✓		Vernier	
3.80	+/-0.030	3.808	✓		Vernier	
1.800	+/-0.010	1.800	✓		Vernier	
R0.50	+/-0.030	R.500	✓		Gaborit	
0.130	+/-0.010	.122	✓		Vernier	
3.41	+/-0.030	3.410	✓		high gage	
3.65	+/-0.030	3.638	✓		Vernier	
2.24	+/-0.030	2.220	✓		Vernier	
45°	+/-0.1°	45°	✓		compa	
R0.25	+/-0.030	R.250	✓		Gaborit	
3.97	+/-0.030	3.960	✓		high gage	
R0.38	+/-0.030	R.380	✓		Gaborit	
Ø0.392	+0.002/-0.000	.393	✓		micronale / bearing	
Ø0.201	+/-0.010	.2018	✓		Pin gage	
0.268	+/-0.010	.265	✓			
R0.260	+/-0.010	R.260	✓		Gaborit	
0.080	+/-0.010	.08	✓		Vernier	
0.300	+/-0.010	.304	✓		Vernier	
0.381	+/-0.010	.377	✓		Vernier	
0.201	+/-0.010	.204	✓		Vernier	
0.580	+/-0.010	.580	✓		Vernier	
0.400	+/-0.010	.398	✓		Vernier	

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DART Aerospace Ltd. 1270 Aberdeen Street Cambridge, ON K6A 1K7 CANADA TEL: 1-813-632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 09/20/18 Container No: S103728 Part: D3121-143 Job No: 181849 Serial No/Batch: S103728 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																																																										
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